

**Work Order ID 69784**

Page 1

Thursday, May 19, 2011 10:35:56 AM

Item ID: D4011-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp, Short

Start Date: 5/19/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 5/27/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/05/19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4011	B								
100	PURCHASING	0.00							
 Waterjet	Memo	0.00							
FLOW CNC Waterjet 304 .080	1-Cut as per Dwg Dwg Rev: <u>B</u> Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
 QC	Memo	0.00							
Quality Control									

B11-5-30

(53)

B11-5-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

8 406107

counted  
(53)

QC

Memo

Quality Control

130

Form as per dwg  
NC BRAKE

0.00

50 406106

(53)

Brake NC

Memo

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

8 406108

(53)

QC

Memo

Quality Control

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES
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Dart Aerospace Ltd

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• NOTE: Date & initial all entries

# Picklist Print

Thursday, May 19, 2011 10:35:53 AM

Page 1

Work Order ID: 69784



Parent Item: D4011-1



Parent Item Name: Clamp, Short

Start Date: 5/19/2011



Required Date: 5/27/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP RevA: New issue DD verified by:EC  
11.05.19 MADE IN HOUSE DD verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA 		Purchased	No			100	sf	27.1000	0.063	2.652632	3.4		
304SS sheet .080										1811-5-30			

Location

Loc Qty

Loc Code

MAT020

27.1

113295

27.1

113295

63

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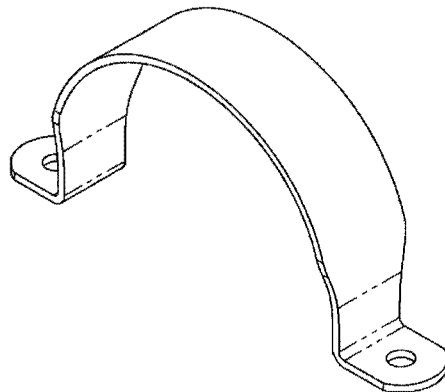




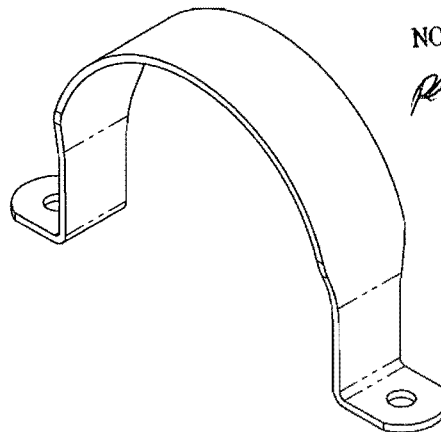


SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 69784

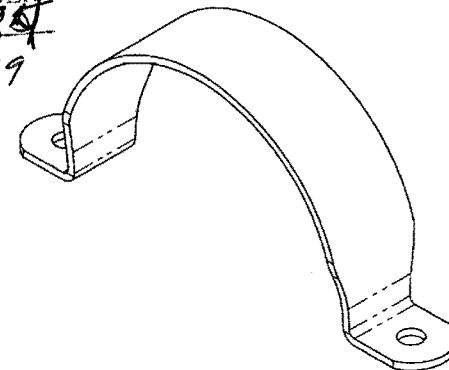
11-05-19



D4011-1 CLAMP, SHORT



D4011-3 CLAMP, LONG



D4011-5 CLAMP, SHORT (OEM)

**RELEASED**  
 2009-11-24  
*MD*

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)  
 PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240  
 REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs EACH

B	SHORTEN HEIGHT OF -1/3 CLAMPS BY 0.125; ADDED -5. REASON: PROVIDE MORE CLEARANCE UPON INSTALLATION ON OEM SKIDTUBES	MB	09.11.11
A	NEW ISSUE	MB	09.10.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JS</i>		
DRAWN	<i>JS</i>		
CHECKED	<i>JS</i>		
MFG. APPR.	<i>JS</i>		
APPROVED	<i>JS</i>		
DE APPR.	<i>JS</i>		
DATE	09.11.11		

**DART AEROSPACE LTD**  
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4011** REV. B  
 SHEET 1 OF 4

TITLE **CLAMP** SCALE  
 NTS

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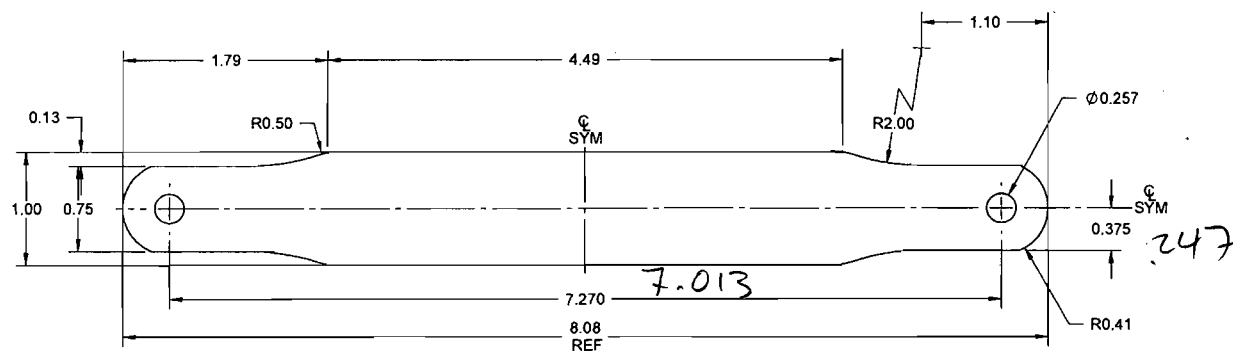
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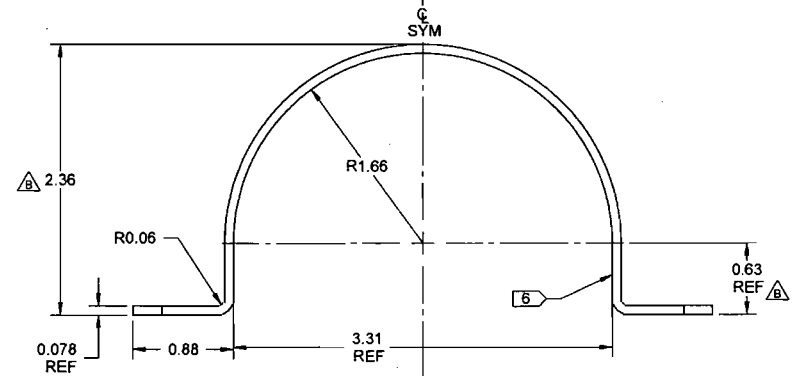
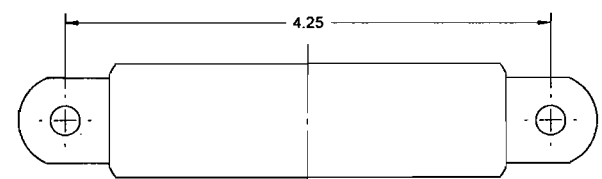
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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



**D4011-1F CLAMP, SHORT FLAT PATTERN**



**D4011-1 CLAMP, SHORT  
(MAKE FROM D4011-1F)**

*w/b 49725*

**RELEASED**  
2009-11-24  
*WFO*

DESIGN	<i>1</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>1</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>1</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>1</i>	D4011	SHEET 2 OF 4
APPROVED	<i>1</i>	TITLE	SCALE
DE APPR.	<i>1</i>	CLAMP	NTS
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8 7 6 5 4 3 2 1

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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